Work Order ID 67160

Wednesday, March 09, 2011 12:51:45 PM

PSAP

Item ID: D3508-5
Revision ID:
Item Name: Wearplate

Accept

Setup Start
Stop

Start Date: 3/9/2011 **Start Qty:** 8.00
Required Date: 3/16/2011 **Req'd Qty:** 8.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** H **Date:** 11-03-9 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3508	Rev C								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				BI 11-3-9			
FLOW CNC Waterjet	1-Cut as per Dwg D3508 ☐Dwg Rev: C ☐Prog Rev: C ☐2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				BI 11-3-9			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

10

Dulo3/10

XS

Pro →

Dart Aerospace Ltd

W/O: 67160		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/03/10	# 120	Took Qty x1 For QC inspection template	8	11/03/10	(x1)		8 11/03/10

Part No: D3508-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 67160

Wednesday, March 09, 2011 12:51:45 PM

ASAP!

Item ID: D3508-5 **Accept** **Setup Start**

Revision ID:

Item Name: Wearplate **Stop**

Start Date: 3/9/2011 **Start Qty:** 8.00 **Cust Item ID:**

Required Date: 3/16/2011 **Req'd Qty:** 8.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Brake NC	NC BRAKE					9			
Brake NC	**Memo**	0.00							
	1-Form on brake using DT8326 and DT8261as per Dwg D3508 SB 11/03/10								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC						M	11	03	10 9
Quality Control	**Memo**	0.00							
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	M 115128					9	RR	11-3-10.	
Powder Coating	**Memo**	0.00							
	START TIME: 3:15. ☐OVEN TEMPERATURE: 300° ☐FINISH TIME: 3:45.								

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Work Order ID 67160

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Item ID: D3508-5
Revision ID:
Item Name: Wearplate
Start Date: 3/9/2011 **Start Qty:** 8.00
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Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				9	0		11/03/11
QC Quality Control	Memo	0.00							
170	Identify as per dwg & Stock Location: FP-21	0.00				9		BR 11-3-11	
Packaging Packaging	Memo	0.00							
180	QC21- Final Inspection - Work Order Release	0.00							11/3/11
QC Quality Control	Memo	0.00							MF 11-03-11

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NOTE: Date & initial all entries

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Picklist Print

Wednesday, March 09, 2011 12:51:53 PM

Work Order ID: 67160

Parent Item: D3508-5

Parent Item Name: Wearplate

Start Date: 3/9/2011 **Required Date:** 3/16/2011

Start Qty: 8.00 **Required Qty:** 8.00

Comments:
IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	90.5938	0.6187	5.210105			

HB11-3-9

Location	Loc Qty	Loc Code
MAT	90.5938	
115953	21.6	
116437	38.7538	
116623	30.24	

116437

10

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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	67160
Description: Wearplate	Part Number:	D3508-5
Inspection Dwg: D3508 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.063	✓		V IB02	
2.813	+/-0.010	2.811	✓		V	
0.375	+/-0.010	.373	✓		V	
5.625	+/-0.010	5.625	✓		T IB01	
28.125	+/-0.010	28.128	✓		T	
31.62	+/-0.030	31.62	✓		T	
Ø0.188	+0.005/-0.001	.191	✓		V	
0.300	+/-0.010	.303	✓		V	
0.300	+/-0.010	.302	✓		V	
0.038	+/-0.010	.035	✓		V	

Measured by:	IB	Audited by:		Prototype Approval:	N/A
Date:	11-3-9	Date:	11/03/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/EC	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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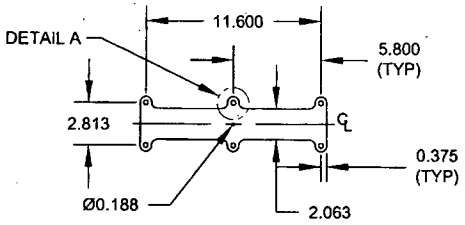
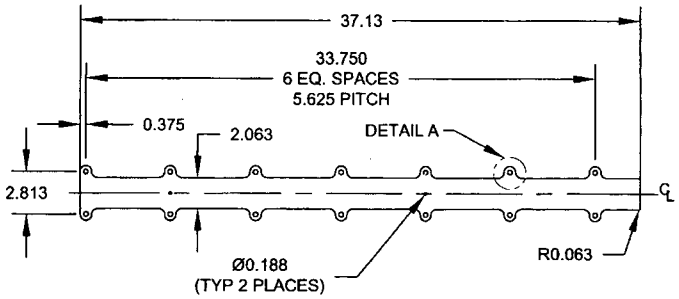
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

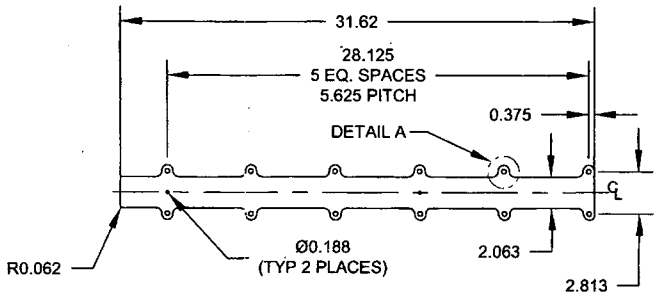
NOTE: Date & initial all entries



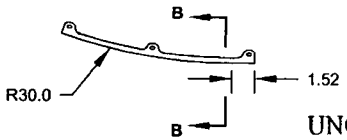
D3508-1 FLAT PATTERN



D3508-3 FLAT PATTERN

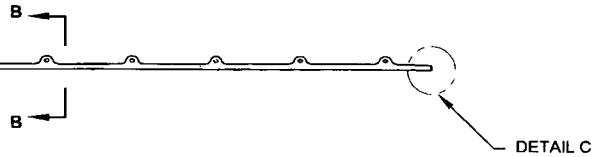


D3508-5 FLAT PATTERN

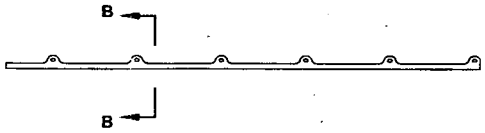


D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)

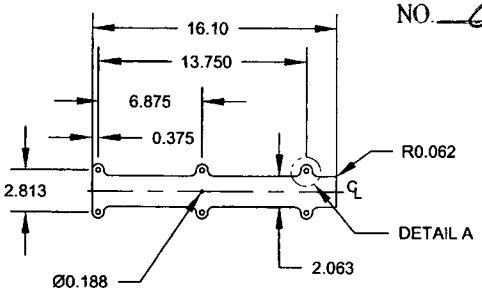
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67160 RI 11-03-9



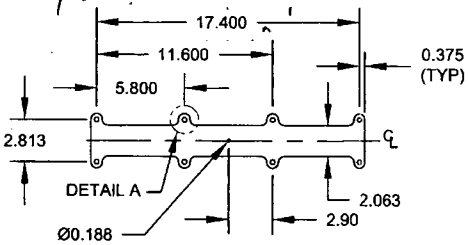
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



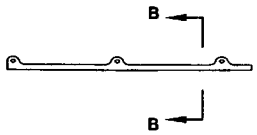
D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)



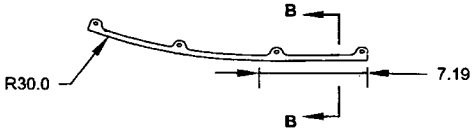
D3508-7F FLAT PATTERN



D3508-9F FLAT PATTERN



D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) WELD PER DART QSI 004
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.015
7) IDENTIFICATION: NONE
8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs D3508-13 - 0.25 lbs

RELEASED 07.11.16

REV.	DESCRIPTION	BY	DATE
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21

DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:8
DATE	07.04.20		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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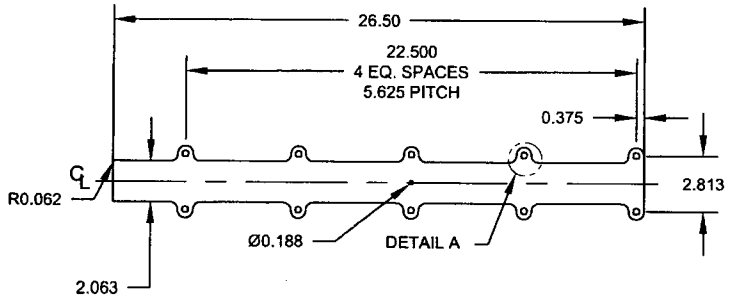
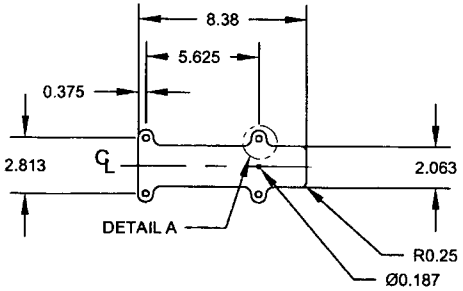
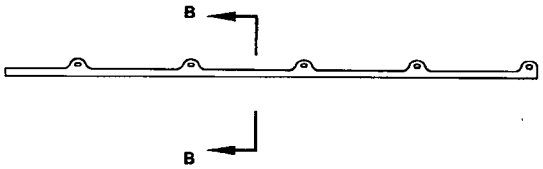


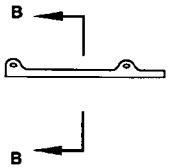
D3508-11F FLAT PATTERN



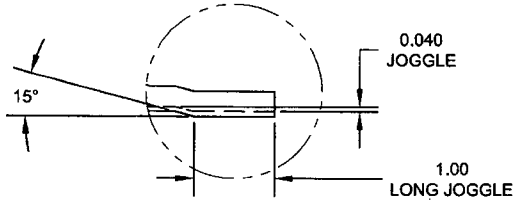
D3508-13F FLAT PATTERN



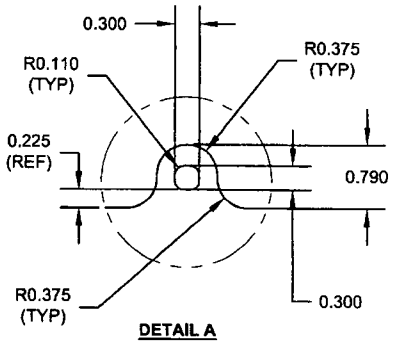
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)

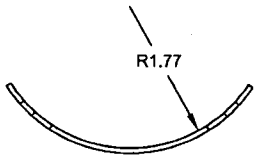


DETAIL C
(SCALE 1:2)

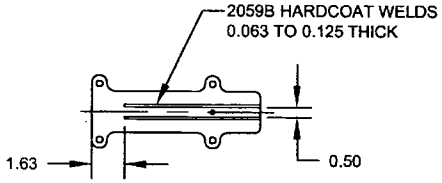


DETAIL A
(SCALE 2:3)

W/0 47160



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	PH	
CHECKED		DRAWING NO. D3508 — REV. C — SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE: WEARPLATE — SCALE 1:6
DE APPR.		
DATE	07.04.20	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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